

Work Order ID 52656

October 5, 2009 2:53:11 PM



Page 1

Item ID:	D2528-3	Accept		Setup	Start	
Revision ID:	C1				Stop	
Item Name:	Backer Plate					
Start Date:	06/10/2009	Start Qty:	10.00	Cust Item ID:		
Required Date:	13/10/2009	Req'd Qty:	10.00	Customer:		
Reference:						

Approvals:	Process Plan:	<u>PL</u>	Date:	<u>09-10-5</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2528	Rev C1								
100	FLOW WATER JET	0.00							
	Waterjet	0.00							
FLOW CNC Waterjet	Memo								
<u>50x2</u> <u>0.3</u>	1-Cut as per Dwg D2528 <input type="checkbox"/> Dwg Rev: <u>C1</u> <input type="checkbox"/> Prog Rev: <u>C1</u> <input type="checkbox"/> 2- Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	0.00							
Quality Control	Memo								
120	QC8- Inspect parts - second check	0.00							
	QC	0.00							
Quality Control	Memo								

B 9-11-6

09/11/09

27

23-10-09

(37)

Work Order ID 52656

October 5, 2009 2:53:11 PM



Page 3

Item ID: D2528-3

Accept



Setup Start



Revision ID: C1

Stop



Item Name: Backer Plate

Start Date: 06/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 13/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: _____	0.00							
	Packaging	0.00							
	Memo								
	Packaging								
170	QC21- Final Inspection - Work Order Release	0.00							
	QC	0.00							
	Quality Control								

9/11/13 SF (27)

09/11/13

MF 09-11-13

Picklist Print

October 5, 2009 2:53:10 PM

Page 1

Work Order ID: 52656



Parent Item: D2528-3RevC1



Parent Item Name: Backer Plate

Start Date: 06/10/2009

Required Date: 13/10/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M5052H32S.063		Purchased	No			110	sf	129.3237	0.3200	1.		
5052-H32 .063 Sheet												

B 9-11-6

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	129.3237	
103755	1.3237	
107276	32	
112442	96	

107 276

58



DESIGN <i>KE</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2528	REV. C SHEET 1 OF 1
DATE 98.12.10		TITLE BACKER PLATE	SCALE 1:1
A	96.12.12	NEW ISSUE	
B	97.10.10	CHANGE SIZE AND HOLE LOCATION	
C	98.12.10	ADD D2528-1 AND -3 (TSR A1037) UPDATED TOLERANCES	
CI	05.04.27	1.46 WAS 1.460; 1.00 WAS 1.000	

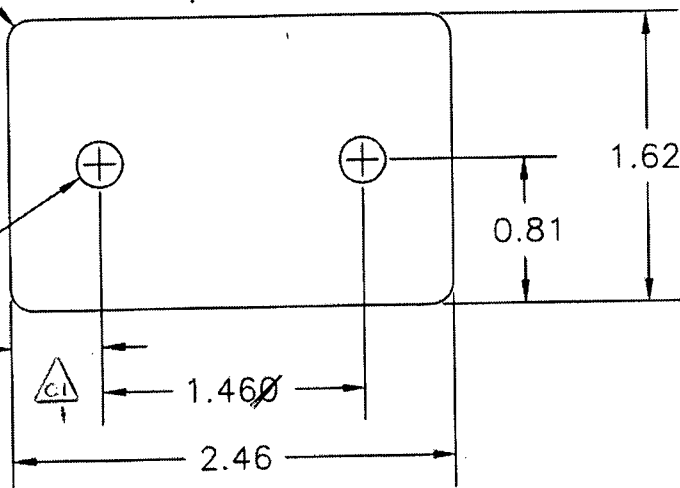
RELEASED
98.12.11 *KE*

R0.13 (TYP)

UNDER REVIEW
[Signature]
01.12.03

Ø0.257 (TYP)

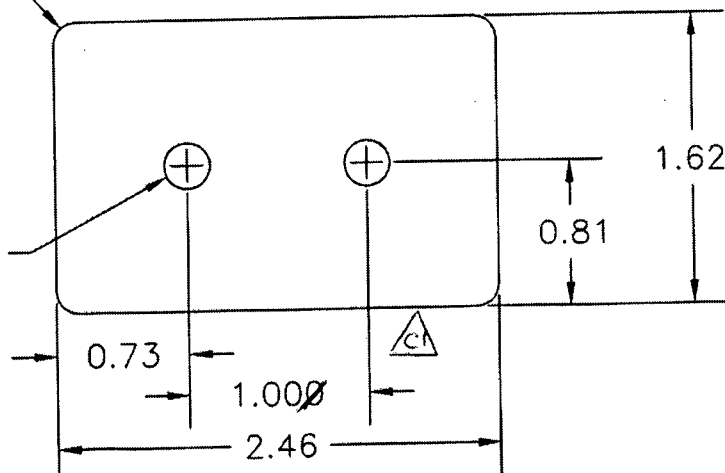
0.50



D2528-1

R0.13 (TYP)

Ø0.257 (TYP)



D2528-3

SHOP
RETURN
ENGINE
UNCONTROLLED
SUBJECT TO
WITHOUT
WORK

NO. 52659

BL 09-10-5

MATERIAL: 5052-H32 OR 5052-H34 (QQ-A-250/8) OR 2024-T3
(QQ-A-250/4) OR 6061-T6 (QQ-A-250/11) 0.063 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED